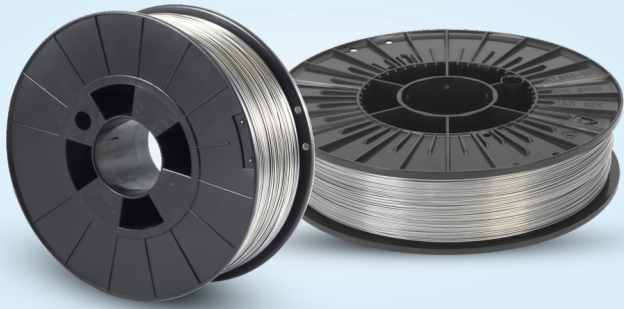




SPECIAL HOT WORKING TOOL STEEL WELDING ALLOY

SMAW	FCAW	MCW
DC+	DC+, 100% Co2 Or 75% Argon-25% CO2	DC+, 100% Co2 Or 75% Argon-25% Co2 Or 90% Argon-10% CO2

TECHNICAL DATA	
Alloy Type :	5% Cr Hot work tool steel
Hardness:	Rockwell C 56-58, as welded
Available Processes:	SMAW, FCAW & MCW
Class:	Hot work tool steel
Heat Treatment::	Use H-12 Procedure

RECOMMENDED CURRENT RANGE

ELECTRODES	
SIZE (MM)	AMPS
3.15	120-150
4.00	160-190
5.00	200-240

FLUX CORED WIRES		METAL CORED WIRES	
SIZE (MM)	AMPS	SIZE (MM)	AMPS
1.6	270-320	1.6	270-320
2.4	330-370	2.4	330-370

FEATURES :

A superior alloy designed especially for extra tough hot and cold work tooling applications. To be used as welded without subsequent heat treatment.

APPLICATIONS :

Carver 9580 has exceptional wear characteristics at high temperatures. Ideal for press dies, screw press dies, and impactor dies. It is also used effectively for cold forming applications such as automotive trim sections, forming dies and blanking dies. Machinability is limited to EDM grinding.

PROCEDURE:

For repairs, prepare area to be welded by removing all cracks, heat checks or other defects. Clean area of any slag, scale, rust or drawing compounds. Preheat die blocks and other units where the entire working surface is to be welded to 425° C. On other alloys preheat and post-heat according to the base metal. Maintain temperature during welding. Use the stringer bead technique. Peen the weld when forgeable to relieve stresses. After welding, cool in still air to 150° C to obtain the ultimate grain refinement and uniform hardness in the weld deposit. Post-heat at 550° C for one hour per inch of thickness. Cool in Still air to room temperature.



ISO 9001-2015
CERTIFIED



MEMBER



MADE IN INDIA

Registered Office :

CARVER ROBOWELD LIMITED

1403, Space Odyssey, 150 Feet Ring Road,
Nr. KKV Hall, Rajkot-360005 Gujarat-India
Mobile : 97277 25540, 97277 25564

E : cwpl@carver.co.in · www.carverroboweld.com

Works :

Survey No. 98-P, Near GIDC Bamanbore Estate
Phase-1, Taluka-Chotila, Bamanbore,
Rajkot-363 520 Gujarat-India.

Mobile : 97277 25555 · Email : cwco@carver.co.in